## **RAKU® TOOL**

# RAMPF discover the future

### CP-6083 R / CP-6084 H

#### **Close Contour Paste**

Machine applied epoxy paste

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#### **Key Properties**

- Good edge strength
- Easy to machine, minimal dust
- Low exothermic
- Layer thickness 25 mm without slump on vertical surfaces

#### **Applications**

- Large-scale models
- Wind turbine blade models
- Boat models

#### **Processing Properties**

|           |          | Unit  | CP-6083-R | CP-6084-H |
|-----------|----------|-------|-----------|-----------|
| Color     | visual   |       | gray      | white     |
| Mix ratio |          | pbw   | 100       | 100       |
| Mix ratio |          | pbv   | 100       | 100       |
| Density   | ISO 1183 | g/cm³ | ca. 0.80  | ca. 0.80  |

|                      |         | Unit | CP-6083-R / CP-6084-H |
|----------------------|---------|------|-----------------------|
| Pot life at 25 °C    | 1000 ml | min  | 60 - 70               |
| Max. layer thickness |         | mm   | 25                    |
| Machinable           |         | h    | 14                    |

#### **Cured / Mechanical Properties**

|                                  |           | Unit      |                             | CP-6083-R / CP-6084-H   |
|----------------------------------|-----------|-----------|-----------------------------|-------------------------|
| Cure                             |           |           | 7 days at RT or 14h at 40°C | 16h at RT + 14h at 80°C |
| Color                            |           | visual    | gray gray                   |                         |
| Density                          | ISO 1183  | g/cm³     | ca. 0.85                    | ca. 0.85                |
| Hardness                         | ISO 868   | Shore D   | 65 - 70                     | 68 - 72                 |
| Coefficient of thermal expansion | ISO 11359 | 10^-6K^-1 | 65 - 75                     | 57 - 67                 |
| Deflection temperature, HDT      | ISO 75    | °C        | 55 - 60                     | 85 - 90                 |
| Glass transition temperature, Tg | DSC       | °C        | 55 - 60                     | 85 - 90                 |
| Compressive strength             | ISO 604   | MPa       | 40 - 45                     | 48 - 52                 |
| Compressive modulus              | ISO 604   | MPa       | 1,500 - 2,000               | 1,800 - 2,300           |
| Flexural strength                | ISO 178   | MPa       | 30 - 35                     | 35 - 40                 |
| Flexural modulus                 | ISO 178   | MPa       | 1,700 - 2,200               | 1,700 - 2,200           |
| Linear shrinkage*                |           | mm/m      | ca. 1.00                    | ca. 1.00                |

<sup>\*</sup>measured on maximum layer thickness as stated above

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#### Processing

The processing temperature and material temperature should be between 20-25°C, never below 18°C. Set up parameters for the dispensing machine are available on request. Check the mixing ratio before you start with the application. Please ensure the constant supply of compressed air. The longer the hose the higher the material pressure.

Avoid applying over 25 mm at once, for thicker layers it is recommended to apply the 2nd layer after the first one has gelled.

| Packaging            |               |
|----------------------|---------------|
| RAKU® TOOL CP-6083-R | 150 kg, 38 kg |
| RAKU® TOOL CP-6084-H | 150 kg, 38 kg |

#### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label. Partly used containers should always be sealed appropriately and used up as soon as possible.

#### Handling precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.

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Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby. The technical data sheet is not a specification, but contains only approximate values.